

Work Order ID: ~~76307~~

November-08-11 1:35:33 PM

Page 1

Item ID: D4151-7

Revision ID:

Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 08/11/2011 Start Qty: 8.00

Required Date: 22/11/2011 Req'd Qty: 8.00

Reference:

Accept

76307

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.J Date: 11/11/08

Tooling:

Date:

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C								

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank to 2.960" long

110

0.00

110

HAAS

HAAS CNC vertical machine #1

Memo

0.00

1-MILL as per folio FA952 & dwg,

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

issue P/O: to Archer P/O: 15679

Machine as per dwg D 4151 REV. C

#85287
tested

04/51-78
76307

8

8

#

76307

10

CL 1112114 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76307

76307

Page 2

November-08-11 1:35:33 PM

Item ID: D4151-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Eyebolt Receiver (Upper)
 Start Date: 08/11/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 22/11/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <i>rec'd</i> *120* QC Quality Control	QC2 Inspect parts off machine FA1/FA1B Memo <i>rec'd + inspect for transit damage. attache c/c to w/o</i>	0.00 0.00							<i>R/24/31</i> <i>(w)</i>
130 *130* QC Quality Control	QC3 Inspect parts - second check Memo	0.00 0.00							<i>8/24/31</i> <i>(w)</i>
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>8/103</i> Memo	0.00 0.00							<i>(104)</i> <i>SP</i> <i>12-6-1</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76307

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76307

Page 3

Item ID: D4151-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Eyebolt Receiver (Upper)
Start Date: 08/11/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 22/11/2011 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

already costed-
#85287
mf
12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-08-11 1:35:39 PM

Page 1

Work Order ID: 76307

76307

Parent Item: D4151-7

D4151-7

Parent Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 08/11/2011

Required Date: 22/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP
Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	12.5000	0.26	2.189474			
M303B2.000X1.750									**				

Location

Loc Qty

Loc Code

MAT050

12.5

118535

12.5

2.6 ~~10~~ 11/12/13

D 4151-7P

X 10

1/4/31 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

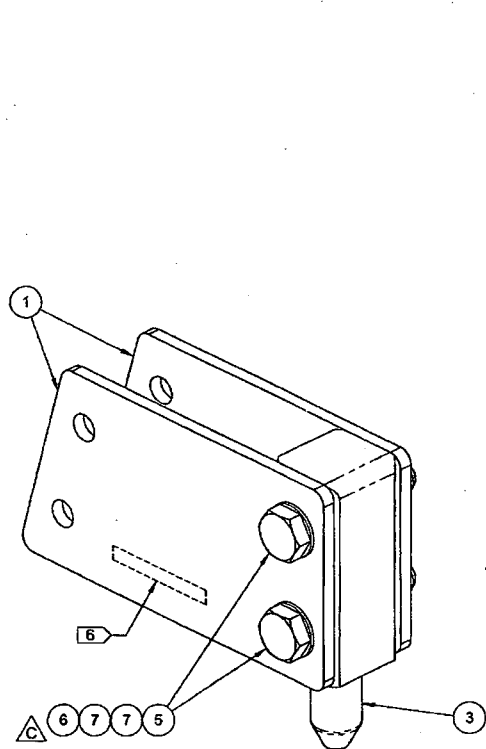
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

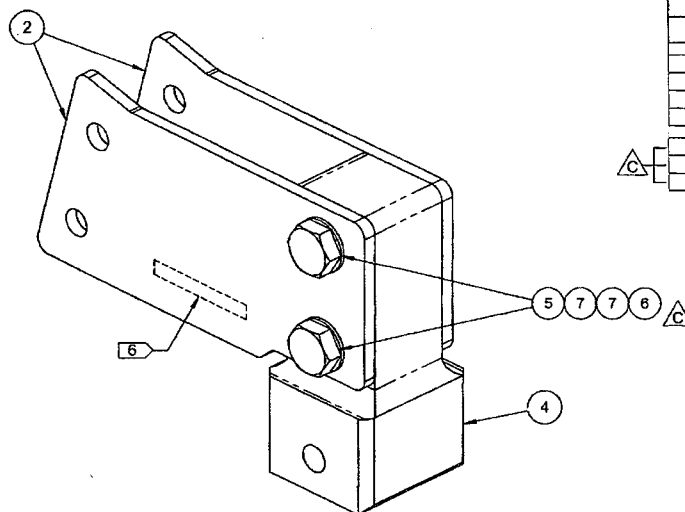
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)



D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76304 M.L.J.

11/11/08

RELEASED
2011-01-28
JMP

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2); 2.84 WAS 2.78 (D3-3) AND 1.85 WAS 1.80 (C1-3) TO PRESERVE 1 SED. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B6-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4151
REV. C
SHEET 1 OF 3
TITLE BASKET FWD HARDPOINT
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

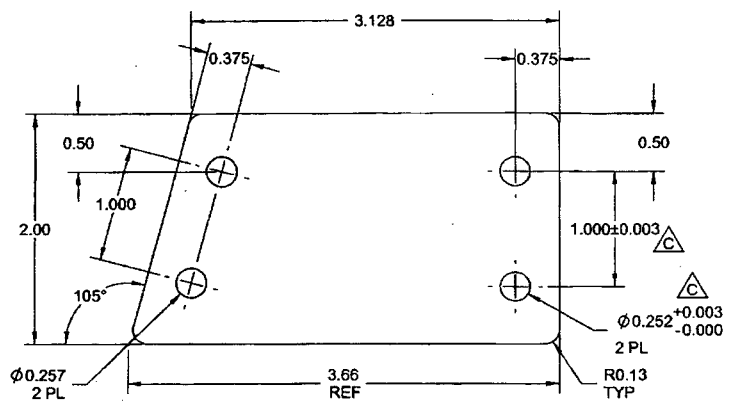
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

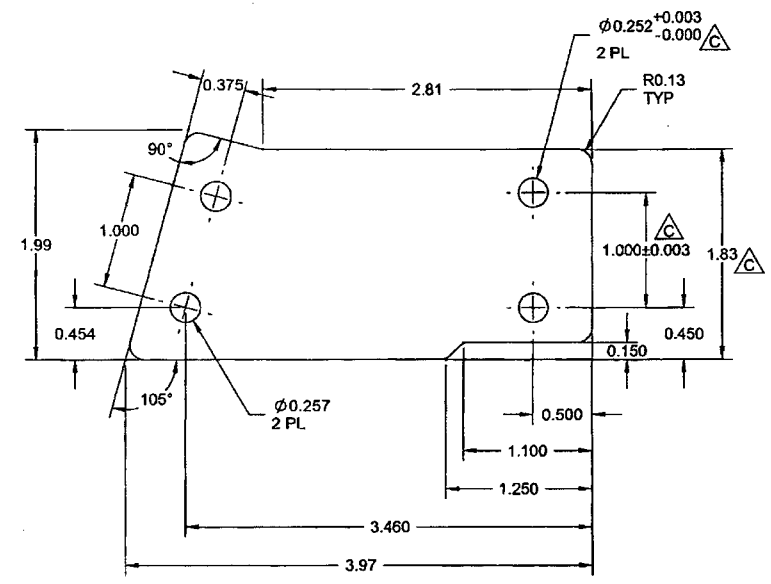
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76307



0.125 REF
D4151-1 LOWER HARDPOINT PLATE



0.125 REF
D4151-3 UPPER HARDPOINT PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
- D4151-1 = 0.24 lbs
- D4151-3 = 0.23 lbs

RELEASED
R 2011-01-08
JMP

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	SC	DRAWING NO. D4151 REV. C
MFG. APPR.		SHEET 2 OF 3
APPROVED	JMP	TITLE BASKET FWD HARDPOINT SCALE NTS
DE APPR.		
DATE	10.12.14	

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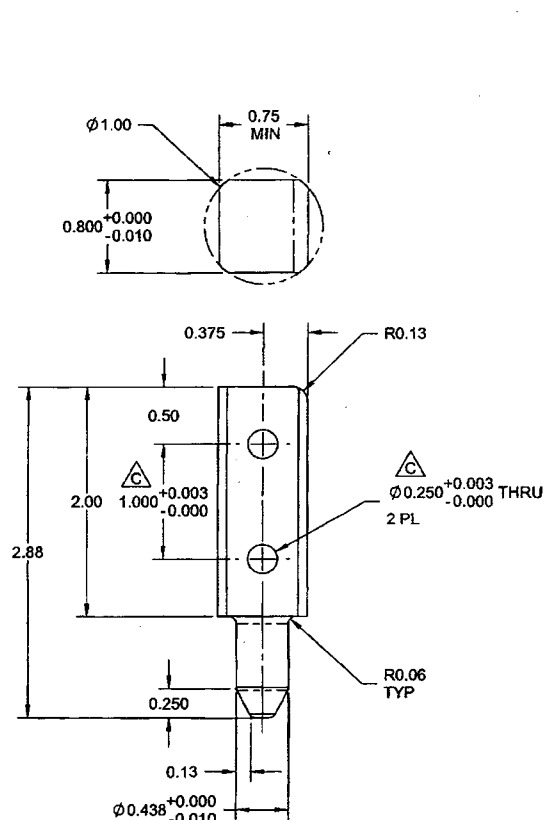
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

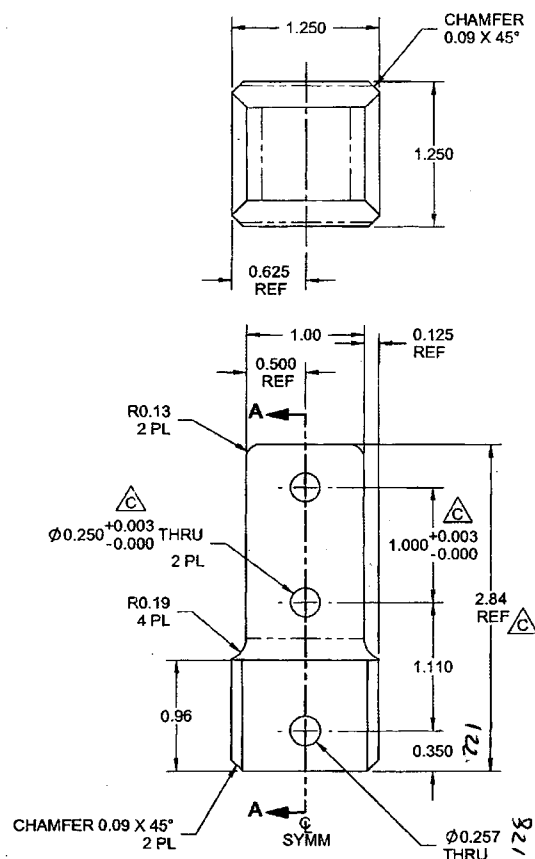
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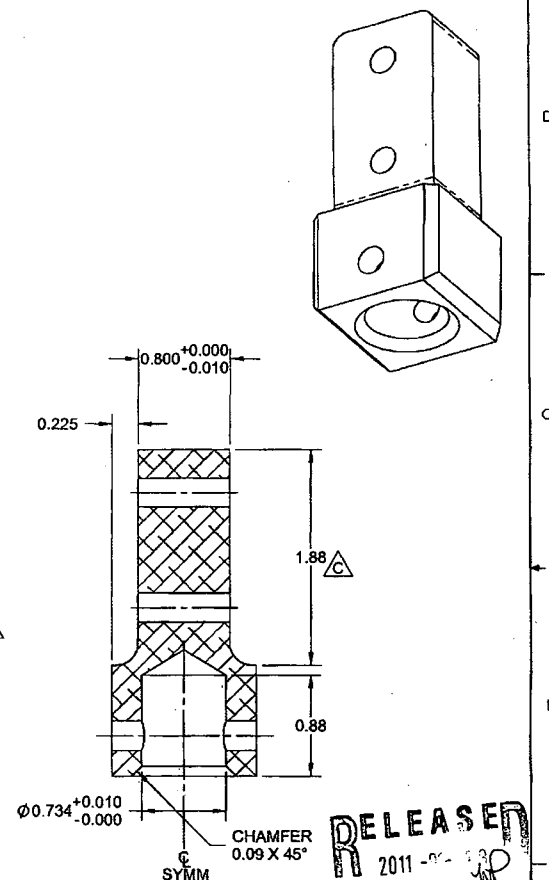
76307



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

2/5

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4151	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE BASKET FWD HARDPOINT	SCALE NTS
DE APPR.			
DATE	10.12.14		

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RELEASED
2011-01-03
RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



2228 Gladwin Cresent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
29/05/2012	134

Ship To

Main Finished Goods Location
Dart Aerospace
1270 Aberdeen Street
Hawksbury, Ontario
K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	29/05/2012	Federal Express	Archer	

Qty	Item Code	Description
10	Sales	D4151-7P FWD Eyebolt Receiver
10	Sales	D3911-3P AFT Eyebolt Receiver
		HST (ON) on sales



1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719

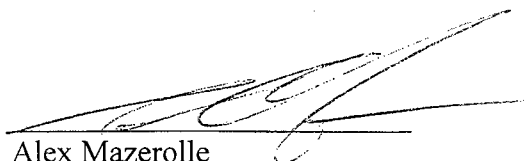
Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

8
(7/05/31)

Po Number	Part Number	Quantities
15679	D4151-7P	10
	D3911-3P	10

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15679 issued by Dart Aerospace Inc.



Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3

Inspection Report

Customer Name Dart Aerospace			QTY 10	DWG # D4151-7		REV. C	Part Name FDW EYEBOLT RECIEVER			Date JAN.27/2012	Lot#	Job # 477-6		
Page 1 of 2			Inspection Interval 100%		Special Notes									
Item #	DWG. Dim	Tolerance	Operator First Off.	QA First Off A R	QA Final A R	2	3	4	5	6	7	8	9	10
	Rev	C	✓	✓	✓									
	Mat	304	✓	✓	✓									
	SUB	None												
	Deburr	Yes	✓	✓	✓									
1	1.250	+/- .005	1.251	✓	✓	1.251	1.252	1.252	1.253	1.253	1.253	1.253	1.253	1.251
2	1.250	+/- .005	1.252	✓	✓	1.252	1.249	1.249	1.252	1.240	1.251	1.250	1.250	1.250
3	.625	REF	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
4	.09	.01	.100	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
5	45°	± .001	45.0	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
6	1.00	+/- .010	1.003	✓	✓	1.002	1.003	1.002	1.002	1.002	1.001	1.001	1.001	1.002
7	0.96	+/- .010	0.96	✓	✓	.096	.096	.096	.096	.096	.096	.096	.096	.096
8	2.84	REF	2.837	✓	✓	2.837	2.837	2.837	2.837	2.837	2.837	2.837	2.837	2.837
9	1.000	+ .003/-0.	1.000	✓	✓	1.000	1.000	1.000	1.000	1.000	1.000	1.000	1.000	1.000
10	1.110	+/- .005	1.110	✓	✓	1.110	1.110	1.110	1.110	1.110	1.110	1.110	1.110	1.110
11	.350	+/- .005	.352	✓	✓	.352	.352	.352	.352	.352	.352	.352	.352	.352
12	Ø .257	+/- .005	.256	✓	✓	.256	.256	.256	.256	.256	.256	.256	.256	.256
13	Ø .250	+ .003/-0.	.2505	✓	✓	.2505	.2505	.2505	.2505	.2505	.2505	.2505	.2505	.2505
14	R0.13	± .01	.128	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
15	2PL	-	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
16	R0.19	± .01		✓	✓									
17	4PL	-	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
18	.500	REF	.5005	✓	✓	PPP	PP	PP	PP	PP	PP	PP	PP	PP
19	.125	REF	.1253	✓	✓	.125	.125	.125	.125	.125	.125	.125	.125	.125
20	.09	REF	.100	✓	✓	.100	.100	.100	.100	.100	.100	.100	.100	.100
21	45°	± .001	45°	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
22	2PL	-	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

